

Split 3

Date: Wednesday, 12/11/2008 1:41:13 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BLUE - LUG ASSEMBLY
Job Number	: 43388 <i>-3</i>		
Estimate Number	: 11745		
P.O. Number	:	Part Number	: D3394043
This Issue	: 12/11/2008 S.O. No. :	Drawing Number	: D3394 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 42567	Material	:
Written By	:	Due Date	: 10/12/2008
Checked & Approved By	: <i>JLD 08/11/12</i>	Qty:	<i>24</i> 100 Um: Each
Comment	: Est Rev: A New Issue 06-01-06 JLM		

Additional Product

Split copy 1

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0735 f(s)/Unit Total: 7.3500 f(s)
D2423 Lug Extrusion
Batch: *B43722*

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut Blank to .850"

cut @ meter

3.0 OUTSIDE SERVICE OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES
Send Blanks To: Metec/Mast Precision Machining
P/O: *7584*
Machine D3394-3 as per Dwg D3394

12/08/11/14 (100)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

P 8/14/9 (100)

5.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Sort 1/6 (100) *center*

Give to Matthew ASAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

20

08-12-10

100

7.0

SPRAY PAINTING

SPRAY PAINTING



Comment: -PRIME B 110 199

Powder coating

white per QSI 005

-PAINT DELFLEET BLUE B 110 077

3:35
3200
4:05

FD 09/01/08

-CLEAR DELFLEET B 110 169

ET 08-12-11

8.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

M-1

09/01/09

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS35489-93	Grommet	M106168

09/01/09

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

09/01/09

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/09

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST473

09/01/09

W/O:		WORK ORDER CHANGES						
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Drawing Name: BLUE - LUG ASSEMBLY

Job Number: 43388

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-09

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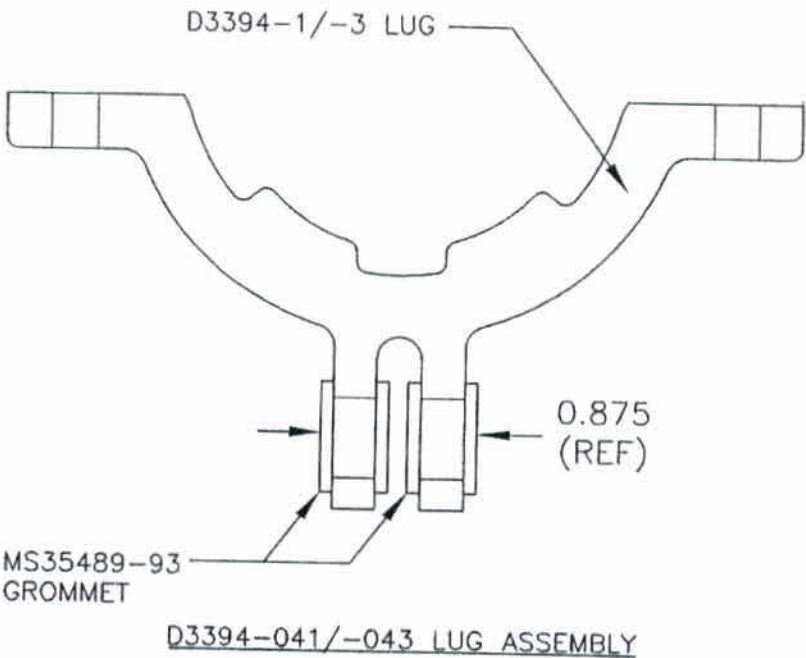
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DART

DESIGN	011	DRAWN BY	011	DART AEROSPACE LTD
CHECKED	11	APPROVED	11	HAWKESBURY, ONTARIO, CANADA
DATE	05.02.14	DRAWING NO.	D3394	REV. A
		TITLE	LUG	SHEET 1 OF 3
A	05.02.14	NEW ISSUE		SCALE 1:1



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3394-041	LUG ASSEMBLY
	X	D3394-043	LUG ASSEMBLY
1		D3394-1	LUG
	1	D3394-3	LUG
2	2	MS35489-93	GROMMET

RELEASED

05.11.14

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43388

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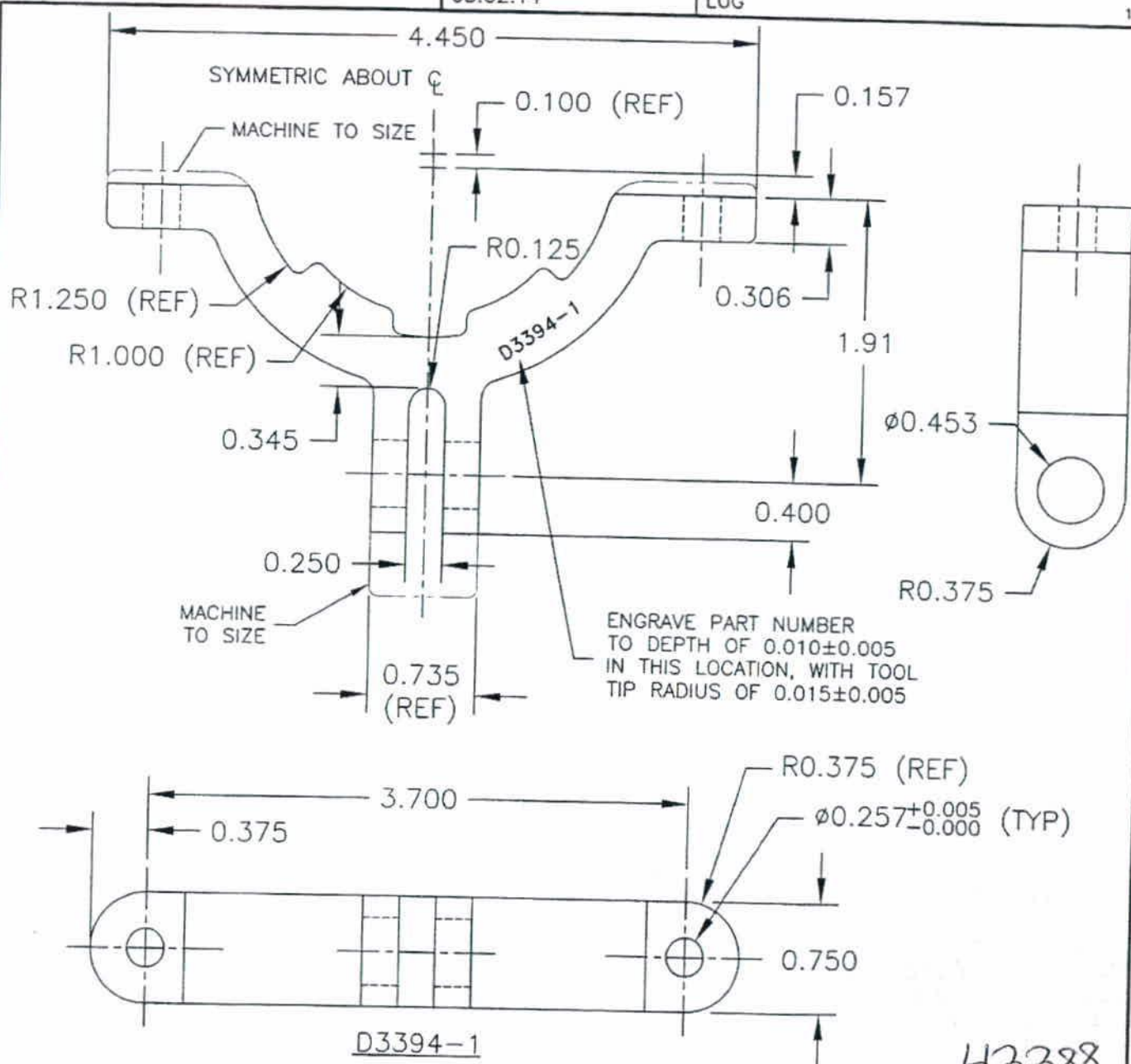
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DART

DESIGN PA	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3394	REV. A
DATE 05.02.14		TITLE LUG	SHEET 2 OF 3
			SCALE 1:1

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05-11-14

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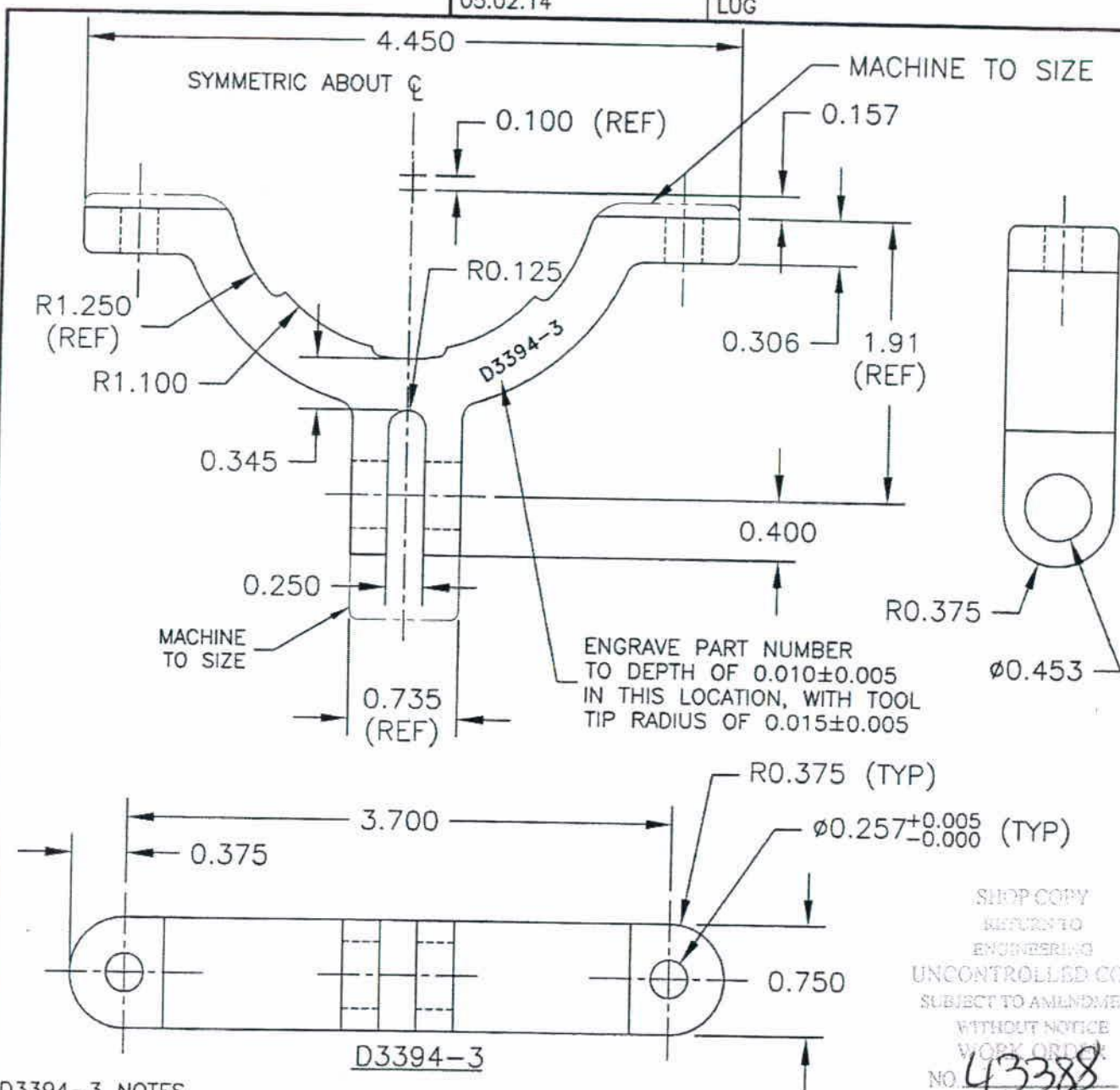
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SHOP COPY
REFER TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43388

RELEASED

05.11.14

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NOTE: Date & initial all entries



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

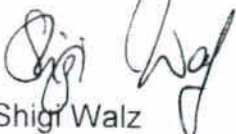
same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
100	D3394-3	Lug	7584

MATERIAL: supplied by DART D2423 B43722

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz


06/2/10

Vankleek Hill, December 9, 2008

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